



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2365
Job Sheet 170307



Part No: D2365

Job Qty: 12 ea

Part Name: Wearplate Pip Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/22/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP Rev A Removed from 9 Digit 05-12-05 JLM (IPP Rev:B Now On Waterjet 08-04-04 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/20/18	1/20/18	0.00	0.00	Start Up Waterjet		DL 18/01/13
100	Waterjet	12 pcs	1/20/18	1/20/18	0.02	0.35	Waterjet1		DL 18/01/13
120	QC	12 pcs	1/20/18	1/20/18	0.00	0.00	QC8		38
130	HandFinish	12 pcs	1/20/18	1/20/18	0.00	0.24	HandFinish1		2018/01/29 JIC
140	QC	12 pcs	1/20/18	1/20/18	0.00	0.00	QC7		38
150	Small Fab	12 pcs	1/22/18	1/22/18	0.00	0.28	Small Fab		DAS 38
160	QC	12 pcs	1/22/18	1/22/18	0.00	0.00	QC5		38
170	Packaging	12 pcs	1/22/18	1/22/18	0.00	0.00	Packaging3		5/21/18 9-89
180	QC21-SA	12 Ea	1/22/18	1/22/18	0.00	0.00	QC21		18/02/01

Part Op 100 - 1-Cut as per Dwg D2365

Descriptions: 150 - Install Insert as per Dwg D2365

DAS
21
9-89

FEB 02 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	FE-832-EF 5000547	24	300	0	0
150-Small Fab	M6061T6S.063	0	214	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wear Plate	1.250Inches $\pm$ 0.010	1.260 1.240		
2	Wear Plate	1.000Inches $\pm$ 0.010	1.010 0.990		
3	Wear Plate	0.625Inches $\pm$ 0.010	0.635 0.615		
4	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240		
5	Wear Plate	0.500Inches $\pm$ 0.010	0.510 0.490		
6	Wear Plate	0.125Inches $\pm$ 0.010	0.135 0.115	Radius	
7	Wear Plate	0.290Inches $\pm$ 0.006 - 0.001	0.296 0.289	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Ther ☐ Eng. Coord. ☐ Water Jet ☐ Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
Description Work Order Deviation									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wav ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> Insu... ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wav ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Insu... ☐ Drill Holes ☐	Start up Operation 01/15/18 Job No: 170307	
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		Wearplate Pip Pin PART NO: D2365 Original Serial #: S032191 Revision: Operation: Change No:							
DART AEROSPACE S032191									
				Wearplate Pip Pin					
Completed By _____		Lead hand / Supervisor Approval Verification _____							
				QC / QA Coordinator Approval _____		<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> <td style="width:50%; vertical-align: top;"> Iled ☐ ce ☐ off center ☐ </td> </tr> </table>		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	Iled ☐ ce ☐ off center ☐
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OTHER : _____		_____							

8	Wear Plate	0.191Inches + 0.006 - 0.001	0.197 0.190	Diameter
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Plex 1/12/18 4:45 PM dart.poulin.mario

WORK ORDER NON-CONFORMANCE / UPDATE

AEROSPACE

QA Closed:

Date:

Work Order update only

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